

Work Order ID 79276

January-24-12 1:02:45 PM

79276

~~HA~~ TESTING

Page 1

Item ID: D412-711-101

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Bubble Window

Start Date: 24/01/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 07/02/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 12/01/24

Tooling:

Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D412-711-101	A

M.L.J 12/02/01

100

0.00

100

DC

Document Control

Memo

Photocopy bluefiles and create labels for PPP D412-711-101 Change 002

0.00

110

0.00

110

HandThermo

Hand Finishing Thermoforming

HAND FINISHING THERMOFORMING

Memo

Set up Machine as per folio FTA 077 and D711W program using mould DT9640

0.00

120

0.00

120

HandThermo

Hand Finishing Thermoforming

HAND FINISHING THERMOFORMING

Memo

Cut Blanks to 37.5" by 43"

0.00

[Handwritten signatures and dates]
2/01/25

[Handwritten signatures and dates]
2/01/25

[Handwritten signatures and dates]
2/01/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 24/01/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 07/02/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

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Work Order ID 79276***79276***

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Item ID: D412-711-101

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Bubble Window

Start Date: 24/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/02/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
160	HAND FINISHING THERMOFORMING								
HandThermo	Memo	0.00				x1			Dh
Hand Finishing Thermoforming	1) Trim off excess flange material 2) Buff out any light scratches or 3) Etch part number and batch number								12/01/26
170		0.00							
170	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00				x1			Dh.
Quality Control	1) Vlsually inspect for clarity, and proper formation.								12/01/30
180		0.00							
180	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							Sr/luho
Quality Control	1) Vlsually inspect for clarity, and proper formation.								

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 79276

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Item ID: D412-711-101 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Bubble Window
 Start Date: 24/01/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 07/02/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
185	QC4- 100% Inspect kits for completeness	0.00							
185									
QC	Memo	0.00							
Quality Control									
190	Identify as per dwg & Stock Location: RED	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

12/21/31
Q

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 79276

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Parent Item: D412-711-101

D412-711-101

Parent Item Name: Replacement Bubble Window

Start Date: 24/01/2012

Required Date: 07/02/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-02-01 JLM
Manufacture in-house 10/06/28 DL

IPP Rev. B.

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MACRLICS.236

Purchased

No

sf

307.0000

21.33333

MACRI ICS 236

**

Plexiglass G .236"

Location

Loc Qty

Loc Code

therm

307

119347

307

21.333335 ft.

12/01/30

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	79276
Description: Replacement Window		Part Number:	D412-711-101
Inspection Dwg: D412-711-101 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:	<u>DL</u>	Date:	12/01/25
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.00	+/-0.030	2.00"	✓		Visual	
1.73	+/-0.030	1.75"	✓		Visual	
1.98	+/-0.030	1.98"	✓		Visual	
1.50	Min	1.52"	✓		Visual	
0.090	Min	0.103"	✓		ULTRA	
0.070	Min	0.095"	✓		ULTRA	
0.050	Min	0.068"	✓		ULTRA	
15.0	+/-0.5	15.0"	✓		TAPE DL-01	

Measured by:	<u>DL</u>	Date:	12/01/30
Audited by:	<u>8</u>	Date:	12/01/31
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
B	10.10.08	New Issue	KJ	<u>[Signature]</u>

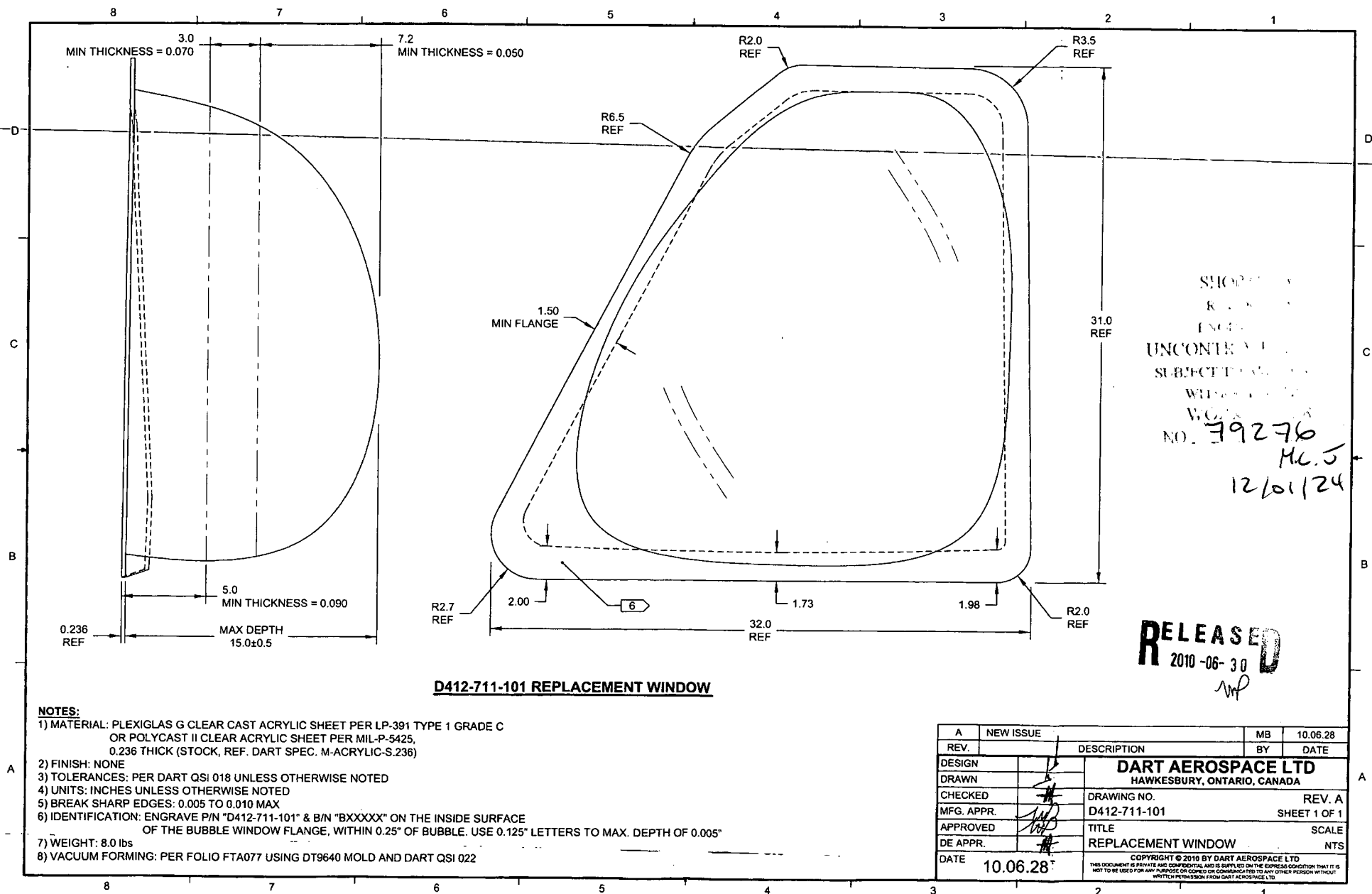
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